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SOVIET MODEL 1921 THREAD-CUTTING SEMIAUTOMATIC LATHE

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One of the most productive methods of cutting fastening threads more than 35-40 millimeters in diameter is a method of high-speed cutting of threads with multiple successive cuts with a hard-alloy tool in an automatic cycle.

The Kuybyshev Srednevolzhskiy Machine Tool Building Plant, under the supervision of the author of this article, has designed a thread-cutting semiautomatic lathe, Model 1921, intended for cutting external and internal, single-cut or multicut, short cylindrical and tapered threads according to the above method.

Testing of the experimental model of the semiautomatic has shown that the time required for cutting single-cut threads on Model 1921 is 1.9-5.6 times less than on thread-milling semiautomatics with three-cutter rotating heads.

The Model 1921 thread-cutting semiautomatic lathe will cut fastening threads to the second class of accuracy and will provide a surface finish within the range of Classes 6 to 7 of GOST 2789-51. -- M-Ya. Tabunshchikov

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